

Work Order ID 162961***162961***

Page 1

Monday, June 19, 2017 11:36:43 AM

Item ID: D066-1016-115

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: JUN 19 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1016	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1016-115 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

JUL 04 2017
Label
DAS 6
9-89DAS 27
9-89
JUL 06 2017
DAS 6
9-89
DAS 28
9-89DAS 27
9-89
JUL 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : ☐							

Work Order ID 162961

Monday, June 19, 2017 11:36:43 AM

162961

Page 2

Item ID: D066-1016-115**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** R66 Basket Mounting Provisions**Start Date:** 6/26/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 6/30/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo Identify and pack for shipping as per PPP D066-1016-115 Location: PPP 159917	0.00 0.00				DAS 27 9-89			JUL 06 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							17/7/16 

DAS
21
9-89**JUL 06 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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162961

D066-1016-115

Required Date: 6/30/2017

Required Qty: 1.00

Comments: IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 17.03.28 as per iin rev.b DD VERF:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-12A		Purchased	No			110	Each	112.0000	8	8			
AN4-12A									**		DAS 6 9-89	JUL 04 2017	DAS 28 9-89
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		10							
				120423		10							
				ST344		102							
				m137412		102							
D5350-041		Manufactured	No			110	Each	3.0000	1	1			
D5350-041									**		DAS 6 9-89	JUL 04 2017	DAS 28 9-89
Fwd Cross Beam Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST260B		3							
				159889		3							
D5350-043		Manufactured	No			110	Each	3.0000	1	1			
D5350-043									**		DAS 6 9-89	JUL 04 2017	DAS 28 9-89
Aft Beam Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST260B		3							
				159891		3							
D5352-1		Manufactured	No			110	Each	116.0000	4	4			
D5352-1									**		DAS 6 9-89	JUL 04 2017	DAS 28 9-89
Cushion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST515		116							
				159892		100							
				161553		16							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Work Order ID: 162961

162961

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

D5354-041	Manufactured	No	110	Each	0.0000	1	1	JUL 06 2017	DAS 28 9-89
D5354-041						**		158814	
R66 Fwd Clamp Assembly, LH									
D5354-042	Manufactured	No	110	Each	2.0000	1	1		DAS 28 9-89
D5354-042						**		DAS 6 9-89	
R66 Fwd Clamp Assembly, RH								JUL 04 2017	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST516	2					
			158807	2			1		
D5355-041	Manufactured	No	110	Each	4.0000	2	2		DAS 28 9-89
D5355-041						**		DAS 6 9-89	
Aft Clamp Assembly								JUL 04 2017	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST516	4					
			158809	4			2		
D5358-1	Manufactured	No	110	Each	6.0000	2	2		DAS 28 9-89
D5358-1						**		DAS 6 9-89	
Cover Plate								JUL 04 2017	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST516	6					
			159085	6			2		
D5445-041	Manufactured	No	110	Each	2.0000	1	1		DAS 28 9-89
D5445-041						**		DAS 6 9-89	
Longitudinal Beam Assembly, LH								JUL 04 2017	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST260B	2					
			159651	2			1		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

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Work Order ID: 162961

162961

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

D5445-042 Manufactured No

110 Each 2.0000 1 1

D5445-042

Longitudinal Beam Assembly, RH

**

DAS
6
9-89

DAS
28
9-89

JUL 04 2017

Location

Loc Qty

Loc Code

ST260B

2

159649

2

MS20392-4C57 Purchased No

110 Each 26.0000 4 4

MS20392-4C57

Pin

**

DAS
6
9-89

DAS
28
9-89

JUL 04 2017

Location

Loc Qty

Loc Code

ST312

26

m137361

26

MS24665-229 Purchased No

110 Each 177.0000 4 4

MS24665-229

Cotter Pin

**

DAS
6
9-89

DAS
28
9-89

JUL 04 2017

Location

Loc Qty

Loc Code

GA

2

118234

2

ST289

175

m135671

175

MS27151-7 Purchased No

110 Each 28.0000 8 8

MS27151-7

PAL NUT

**

DAS
6
9-89

DAS
28
9-89

JUL 04 2017

Location

Loc Qty

Loc Code

ST275

28

m134055

4

m137361

4

m137459

20

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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162961

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,030.000

8

8

NAS1149D0463.I

**

Washer

DAS
6
9-89

JUL 04 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

40

M135056

40

ST260a

2000

M137699

2000

ST263

1990

M137371

1988

M137544

2

NAS1149F0563P

Purchased

No

110

Each

130.0000

4

4

NAS1149F0563P

**

Washer

DAS
6
9-89

JUL 04 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST262

130

m136983

130

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

5.0 PARTS LIST

Qty -011	Qty -012	Qty -111	Qty -113	Qty -115	Qty -121	Qty -123	Part Number	Description
X							D066-1016-011	R66 QR HELI-UTILITY-BASKET, LH
	X						D066-1016-012	R66 QR HELI-UTILITY-BASKET, RH
		X					D066-1016-111	CROSSTUBE CLAMP KIT
			X				D066-1016-113	CROSSTUBE CLAMP + LONGITUDINAL BEAM KIT
1	1			X			D066-1016-115	BASKET MOUNTING PROVISIONS KIT
					X		D066-1016-121	FWD LID GAS SPRING UPGRADE (OPTIONAL)
						X	D066-1016-123	FWD FIXED STEP UPGRADE (OPTIONAL)
1							D5337-011	BASKET ASSEMBLY, LH
	1						D5337-012	BASKET ASSEMBLY, RH
					2		D3953-17	GAS SPRING SPACER
					1		D3953-19	GAS SPRING BRACKET
					1		D3953-21	GAS SPRING BRACKET
					2		D3953-3	GAS SPRING STUD
					2		D3953-7	GAS SPRING SPACER
					2		D3953-9	GAS SPRING WASHER
					1		D3969-7	GAS SPRING
				1			D5350-041	R66 FWD CROSS BEAM ASSEMBLY
				1			D5350-043	R66 AFT CROSS BEAM ASSEMBLY
		4	4	4			D5352-1	CUSHION
		1	1	1			D5354-041	R66 FWD CLAMP ASSEMBLY, LH
		1	1	1			D5354-042	R66 FWD CLAMP ASSEMBLY, RH
		2	2	2			D5355-041	R66 AFT CLAMP ASSEMBLY
1	1						D5357-041	STRUT ASSEMBLY
		2	2	2			D5358-1	COVER PLATE
			1	1			D5445-041	LONGITUDINAL BEAM ASSEMBLY, LH
			1	1			D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
						1	D5510-041	FWD STEP
					2		AN310C4	NUT, CASTELLATED
					4		AN3-14A	BOLT
			8	8			AN4-12A	BOLT
						2	AN4-14A	BOLT
				4			MS20392-4C57	PIN
					4		MS21042L3	NUT
						2	MS21042L4	NUT
				4			MS24665-229	COTTER PIN
					2		MS24665-300	COTTER PIN
		8	8	8			MS27151-7	STAMPED NUT
					2		NAS1149C0432R	WASHER
			8	8		4	NAS1149D0463J	WASHER
				4			NAS1149F0563P	WASHER
					8		NAS1149F0332P	WASHER

Work Order ID 162961

162961

Monday, June 19, 2017 11:36:43 AM

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Item ID: D066-1016-115

Revision ID:

Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017 Start Qty: 1.00

Required Date: 6/30/2017 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Run Start *NR1*
Stop *NR2*

Approvals: Process Plan:  Date: JUN 19 2017
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D066-1016	B

100

Document Control
DOCUMENT CONTROL

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D066-1016-115 CHG001

0.00

DAS
5
9-89

JUL 05 2017

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.03

JUL 01 2017